








Work Order ID 51336

August 19, 2009 11:25:58 AM




Page 1

Item ID: D3836-041 Accept  Setup Start 
Revision ID: A Stop 
Item Name: Rib Assembly (Basket Lid, LH)
Start Date: 08/19/2009 Start Qty: 2.00  Cust Item ID:
Required Date: 08/25/2009 Req'd Qty: 2.00  Customer:
Reference:


Approvals: Process Plan: MF Date: 09-08-19 Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3836	Rev A

100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- cut D3836-1 and D3836-3 rib as per dwg D3836-2- remove identification markings 3- deburr								

SAD 09-08-20 (2)

110		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

=) 8 09/08/20 (2) 42

120		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- weld D3836-1 to D3836-3 and drill hole (3/16") using DT9447 jig and open to finish size as per dwg D3836-2- weld D2327-3 spacer bushing as per dwg D3836 A/R ER316 S.S. Rod Batch: 1108775 3- grind weld flush where indicated on dwg D								

sp 09.08.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID:	D3836-041	Accept		Setup	Start	
Revision ID:	A				Stop	
Item Name:	Rib Assembly (Basket Lid, LH)					
Start Date:	08/19/2009	Start Qty:	2.00			
Required Date:	08/25/2009	Req'd Qty:	2.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:
	QC:	Date:	SPC (Y/N):	Date:

Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00							
						Cpl	09	08	25
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
						=>	8	02/08/25	
						-041			
						(12)			
150 Packaging Packaging	Identify as per dwg & Stock Location: <u>Basket</u> Memo	0.00 0.00							
						PD	09-08-25	(2)	

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

09/08/26  PL 09-8-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

August 19, 2009 11:25:58 AM

Page 1

Work Order ID: 51336

Parent Item: D3836-041RevA

Parent Item Name: Rib Assembly (Basket Lid, LH)

Comments:

Start Date: 08/19/2009

Required Date: 08/25/2009

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2327-3RevD Spacer Bushing		Manufactured	No			100	Each	54.0000	2.0000			

Warehouse Loc Qty Loc Code
Location

Premier

Mezz 54
44274 45
44365 9

✓ 2

M304TS0.750W.065 Purchased No 100 f 1,352.362 3.7491
304 SQ Tube .75x.75x.065W

Warehouse Loc Qty Loc Code
Location

Main Warehouse

MAT 6.307103691
112051 -0.7368363
112263 7.04394

3.7491

Main Warehouse

WA 1346.0554
112263 1.6735
112344 344.3819
112398 1000

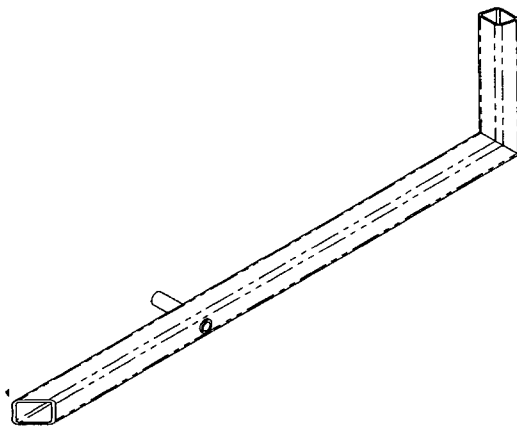
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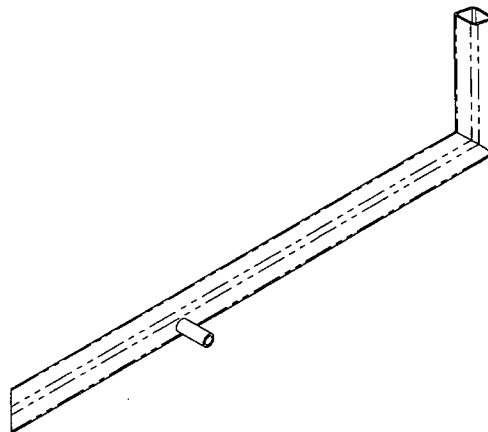
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3836-042 RIB ASSY (BASKET LID, RH)



D3836-041 RIB ASSY (BASKET LID, LH)

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3836-041	RIB ASSY (BASKET LID, LH)
2		X	D3836-042	RIB ASSY (BASKET LID, RH)
3	1	1	D2327-3	SPACER BUSHING
4	1		D3836-1	RIB
5		1	D3836-2	RIB
6	1	1	D3836-3	RIB

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 51336

mf 09-08-19

RELEASED
08/11/18 MP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.99 lbs EACH
- 8) WELD PER DART QSI 004

A	NEW ISSUE	MB	08.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.24		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3836** REV. A
SHEET 1 OF 3
TITLE **RIB ASSY (BASKET LID)** SCALE NTS

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

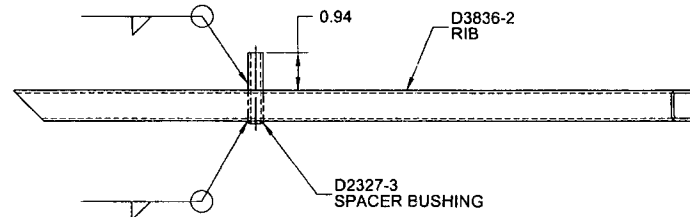
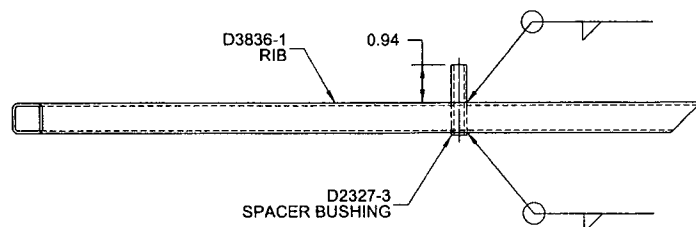
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

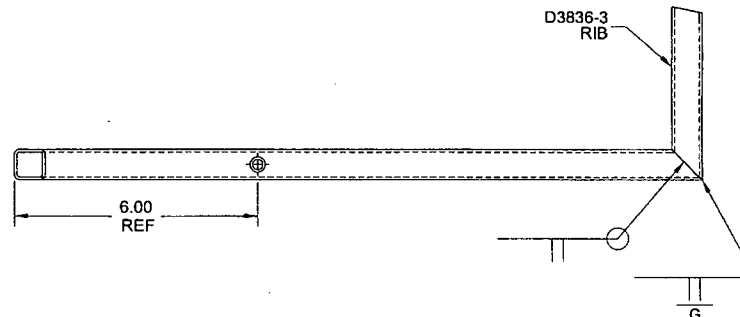
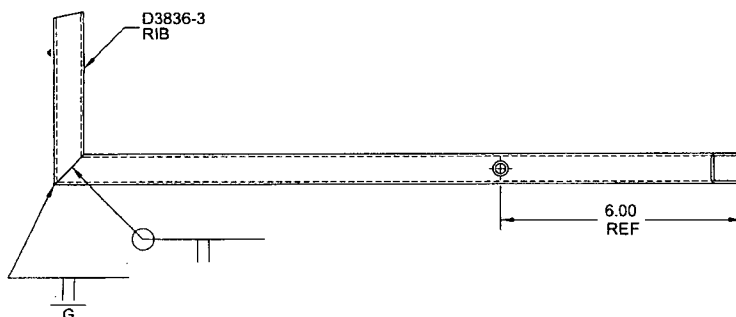
D

D



C

C



B

B

D3836-041 RIB ASSY (BASKET LID, LH)

D3836-042 RIB ASSY (BASKET LID, RH)

51336

RELEASED
08/11/18

A

A

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3836	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
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8 7 6 5 4 3 2 1

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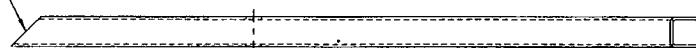
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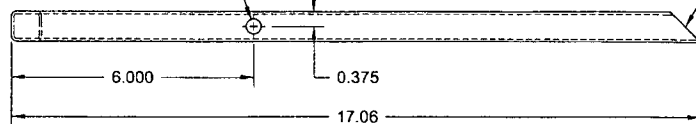
NOTE: Date & initial all entries

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CHAMFER

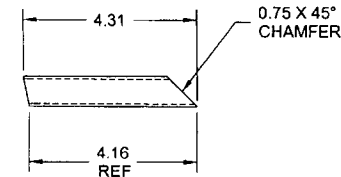


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0.75 X 45°
CHAMFER



D3836-1 RIB



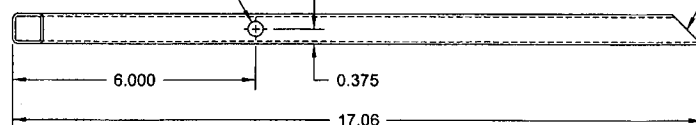
D3836-3 RIB

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CHAMFER

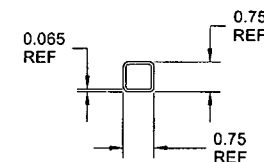


$\varnothing 0.375^{+0.020}_{-0.000}$ THRU

0.75 X 45°
CHAMFER



D3836-2 RIB



**TYPICAL SECTION
VIEW**

RELEASED
08/11/84

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.78 lbs EACH; D3836-3 = 0.19 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.		D3836	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
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Dart Aerospace Ltd

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